

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014042**Date Inspected:** 12-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu Xian Ping**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:****Summary of Items Observed:**

On this day Caltrans OSM Quality Assurance (QA) Inspector Daniel Barrentine was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhen Hua Port Machinery Company (ZPMC) at Chang Xing Island in Shanghai, China. QA Inspector observed and/or found the following:

**Bay 9**

Welding of U-rib stiffeners in deck panel u-rib labeled DP3080A-001 (1 rib). The welder was identified as 059443.

Fit up and welding of deck panel U- rib stiffeners in deck panel u-rib labeled DP3076A-001 (1 rib). The welder was identified as 201840.

Fit up of u-rib stiffeners in deck panel u-rib labeled DP3078A-001 (1 rib).

**Bay 8**

Grinding of weld repaired areas on traveler rail 10TR3-026.

Grinding end prep on 11TR3-013.

Welding of edge panel DP3142-001,002,005,006,007,008. The welders were identified as 048801 and 051246. The welding procedure was identified as WPS-B-T-4132. The ZPMC QC was identified as Zheng Zhi Wei. The

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ZPMC CWI was identified as Li Jia.

### Bay 6

Grinding and weld repair of various handrails. The welds were identified as WJF-0-202, and WJF-0-193. The welders were identified as 049769 and 057795 respectively. The welding procedure was identified as WPS-B-T-3211-Tc-U4c. The ZPMC QC was identified as Shu Yanghua. The ZPMC CWI was identified as Li Jia.

In process heat straightening of floor beam FB 3163A.

### Bay 3

Welding of floor beam FB3106-001-052, 053. The welders were identified as 050977 and 208035. The welding procedure was identified as WPS-B-T-2132-3. The ZPMC QC was identified as Shi Lei. The ZPMC CWI was identified as Tian Lei.

Welding of floor beam FB7001-001-002. The welder was identified as 206386. The welding procedure was identified as WPS-B-T-2132-3. The ZPMC QC was identified as Shi Lei. The ZPMC CWI was identified as Tian Lei.

### Bay 2

Welding of floor beam FB3212-001-113, 118. The welder was identified as 045240. The welding procedure was identified as WPS-B-T-2232-Tc-U4b-F. The ZPMC QC was identified as Shi Lei. The ZPMC CWI was identified as Tian Lei.

Weld repair of floor beam FB3189-001-003 pursuant to B-WR-12814. The welder was identified as 045209. The welding procedure was identified as WPS-345-FCAW-1G(1F0-FCM-Repair-1. The ZPMC QC was identified as Shi Lei. The ZPMC CWI was identified as Tian Lei.

### Bay 1

Welding of traveler rail 20TR1-042-003. The welding procedure was identified as WPS-B-T-2232-Tc-U5-F. The welder was identified as 219188. The ZPMC QC was identified as Ai Wei. The ZPMC CWI was identified as Tian Lei.

Welding of traveler rail 20TR2-032-005. The welding procedure was identified as WPS-B-T-2232-Tc-U5-F. The welder was identified as 216575. The ZPMC QC was identified as Ai Wei. The ZPMC CWI was identified as Tian Lei.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.

### Summary of Conversations:

No Relevant Conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for

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your project.

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**Inspected By:** Barrentine,Daniel

Quality Assurance Inspector

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**Reviewed By:** Carreon,Albert

QA Reviewer